

Date: Monday, 11/08/2008 2:45:41 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number :	41131		
Estimate Number :	10939		
P.O. Number :		Part Number :	D29382
This Issue :	11/08/2008	Drawing Number :	D2938 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	C
Previous Run :	39890	Material :	
Written By :		Due Date :	12/09/2008
Checked & Approved By :	<u>MD 08.8.11</u>	Qty:	10 Um: Each
Comment :	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length
 (D6101-003)

Batch No: B34873 MD 08/08/27 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Debur

MD 08/08/27 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

MD 08/08/27 (10)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

MD 08/08/27 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41131

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F.

08/08/28

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/H

08/08/29

(X10)

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:20

OVEN TEMPERATURE:

320°

FINISH TIME:

12:50

M-H

08/09/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JS

08-09-02

(X10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 429

JS

08/09/02

(X10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03

Job Completion



M-F 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41131
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	.127	.115	.116		
B	0.100	0.140		.128	.128	.114	.116		
C	0.100	0.140		.116	.117	.112	.113		
D	0.210	0.230		.229	.222	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.511	.511	.512		
I	1.572	1.582		1.577	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.499	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.237	.238	.237	.238		
N	0.100	0.140		.121	.119	.119	.119		
O	0.540	0.560		.546	.548	.548	.548		
P	0.490	0.510		.500	.501	.499	.499		
Q	3.715	3.725		3.716	3.718	3.718	3.717		
R	2.720	2.760		2.740	2.740	2.741	2.740		
S	0.240	0.270		.260	.253	.254	.254		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.627	1.628	1.629	1.627		
V	1.362	1.372		1.366	1.367	1.365	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.259	1.256	1.260	1.261		
Y	1.565	1.585		1.568	1.570	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	08/08/27

Audited by:	J.F.
Date:	08/08/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 41131
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.117	.116	.116		
B	0.100	0.140		.116	.117	.116	.116		
C	0.100	0.140		.114	.114	.114	.173		
D	0.210	0.230		.224	.224	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.570	.571	.571	.570		
I	1.572	1.582		1.577	1.575	1.566	1.577		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.119	.119	.119		
O	0.540	0.560		.547	.547	.547	.547		
P	0.490	0.510		.501	.499	.502	.502		
Q	3.715	3.725		3.716	3.717	3.719	3.717		
R	2.720	2.760		2.740	2.741	2.740	2.740		
S	0.240	0.270		.253	.254	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.629	1.629	1.627	1.627		
V	1.362	1.372		1.366	1.365	1.366	1.366		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.574	1.573	1.574	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	cmf
Date:	08/08/27

Audited by:	JF
Date:	08/08/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41131
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

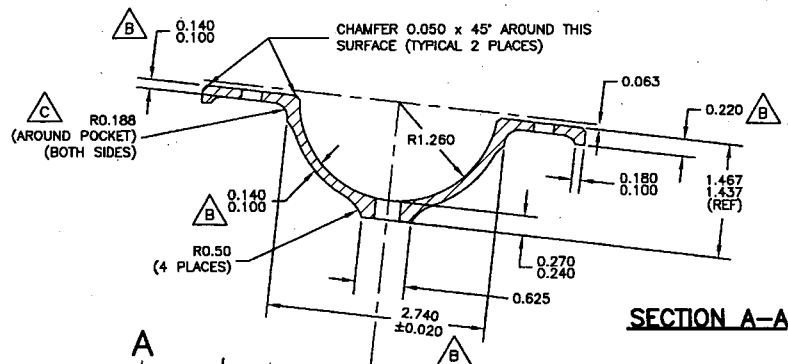
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.116				
B	0.100	0.140		.116	.116				
C	0.100	0.140		.114	.116				
D	0.210	0.230		.224	.224				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.506	2.506				
H	0.510	0.515		.516	.516				
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.499	2.499				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.119	.119				
O	0.540	0.560		.547	.547				
P	0.490	0.510		.502	.501				
Q	3.715	3.725		3.717	3.717				
R	2.720	2.760		2.746	2.746				
S	0.240	0.270		.254	.253				
T	0.100	0.180		.146	.146				
U	1.625	1.635		1.628	1.628				
V	1.362	1.372		1.366	1.368				
W	0.316	0.321		.326	.326				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585		1.574	1.574				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

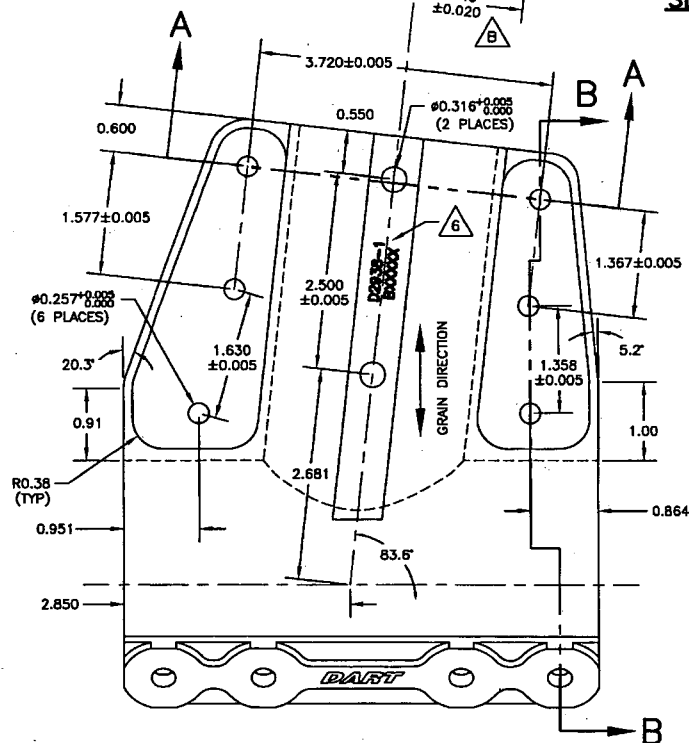
Measured by:	<i>[Signature]</i>
Date:	06-08-26

Audited by:	J.F.
Date:	08/08/28

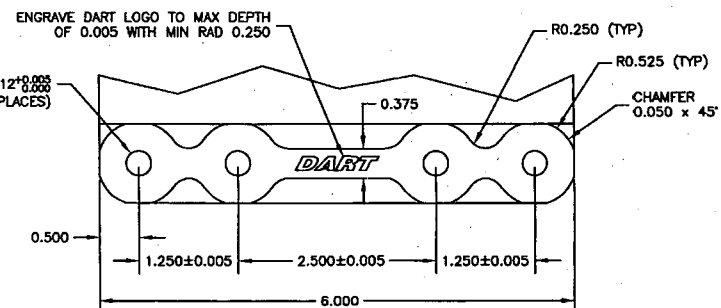
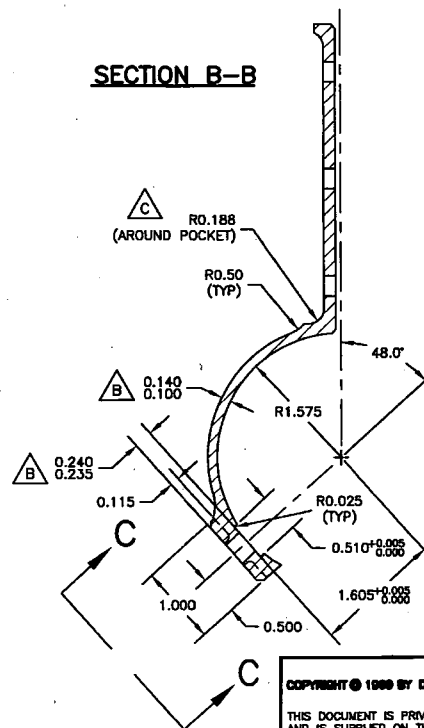
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



SECTION A-A



SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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DART DART AEROSPACE USA, INC.
BELLINGHAM, WA
DRAWING NO. D2938
REV. C
SHEET 1 OF 1
SCALE 2:3

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